

Work Order ID 85486

\*85486\*

Page 1

June-08-12 10:13:54 AM

Item ID: D2739

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: 350 I Beam

Start Date: 08/06/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: M-L-J

Date: 12/06/08

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

\*100\*

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Cut D2600-5 to length as per Dwg D2739.  
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739  
3-Use uni-bit to open holes to finish size as per Dwg D2739.  
4-Bevel Fwd end of extrusion and Deburr holes and ends.  
5-Deburr

120

Chemical Conversion Coat per QS1005 4:1

0.00

\*120\*

HandFinish

Memo

0.00

Hand Finishing

3/12/06/26  
P/O

6 NG 12687



NCR: ☒ Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Ant Date: 12/07/10QA Closed: ck Date: 12/7/10

Work Order: <u>85486</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D2739</u>		Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>12-1570</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>	
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data				AT inspection Found <u>1</u> web was cut 1.0" TO short.		Scrap <u>NO</u> replace.			
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

## FAULT CATEGORY

Landing Gear	Hardware	General	
<input type="checkbox"/> Bending Passes Below Min	<input type="checkbox"/> Breaking	<input type="checkbox"/> Burrs	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Missing	<input type="checkbox"/> Contamination	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Cracks	<input type="checkbox"/> Size/Length	<input checked="" type="checkbox"/> Cut Too Short	<input type="checkbox"/> Off-Set
<input type="checkbox"/> Crushed/Crimp at Bending	<input type="checkbox"/> Spinning	<input type="checkbox"/> Documentation/Data	<input type="checkbox"/> Orientation Misread
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Threading	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Other	<input type="checkbox"/> Wrong	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Inspection Unqualified	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ripples on Inner Bend	<input type="checkbox"/> Misaligned	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Jigs/Fixtures/Tooling	<input type="checkbox"/> Part Lost
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Over/Undersized	<input type="checkbox"/> Kit Incorrect	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Too Many	<input type="checkbox"/> Kit Missing	<input type="checkbox"/> Raw Material
			<input type="checkbox"/> Set-up
			<input type="checkbox"/> Supplier
			<input type="checkbox"/> Temperature/Cure
			<input type="checkbox"/> Weld
			<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other



# Work Order ID 85486

**\*85486\***

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Item ID: D2739

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: 350 I Beam

Stop

**\*NS2\***

Start Date: 08/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

DP 12-6-28 (5)

140

Identify as per dwg & Stock Location: LG

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

5 ~~5~~ CF 12-6-27

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

12/7/4

12-07-4



# Picklist Print

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Page 1

Work Order ID: 85486

**\*85486\***

Parent Item: D2739

**\*D2739\***

Parent Item Name: 350 I Beam

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	114.0000	1	6			

**\*D2600-5-108\***

Extrusion 'I Beam' thin

\*\*

## Location

## Loc Qty

## Loc Code

LG

114

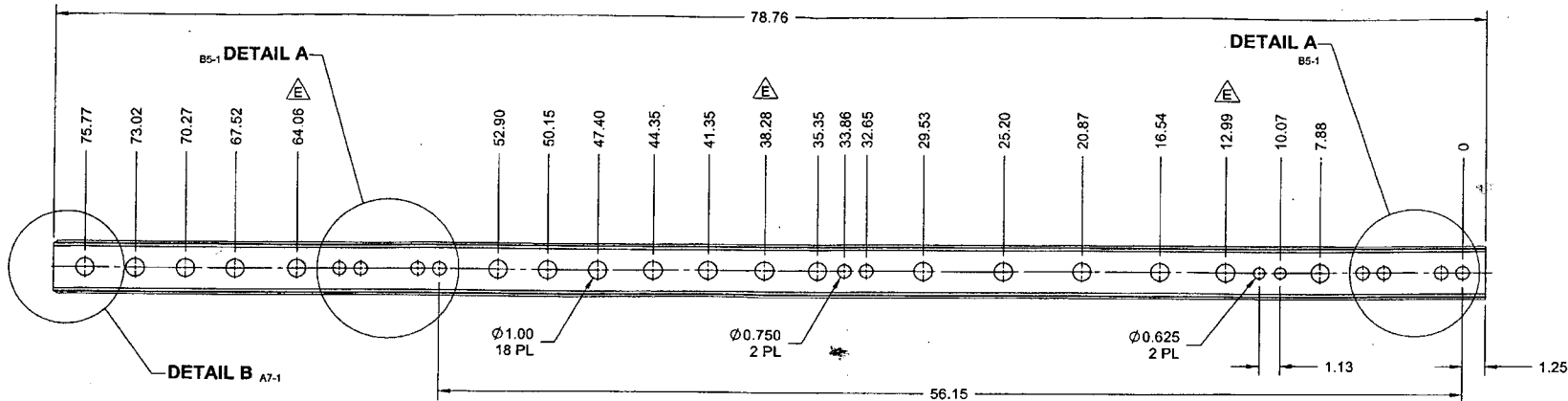
47814

20

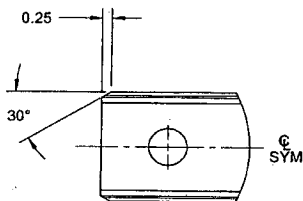
73909

94

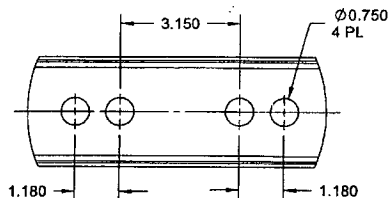
BB 12/06/26



**D2739 WEB**



**DETAIL B**  
SCALE 3X C7-1



**DETAIL A**  
SCALE 3X D7-1, D2-1

**NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85486 MJS  
12/06/08

**RELEASED**  
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.08 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	08.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D2739</b> TITLE <b>WEB</b> REV. _____ SHEET 1 OF 1 SCALE _____ NTS _____	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
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